

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012931**Date Inspected:** 07-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OUTSIDE YARD**ULTRASONIC INSPECTION****OBG 9CE**

ABF Request No: 04062010-01

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Rejectable indication observed during the inspection. Inspection was carried out on repair areas. Weld identification numbers were.

CA063-004 (9CE- DP to EP, CW side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

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For more information refer the CT report dated on 04/07/ 2010.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

BIKE PATH #027

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for weld BK-001-027-005 located on PCMK BK # 027. ZPMC QC Mr. Wang Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

OBG SEGMENT 8AW

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging at the weld between deck panel and edge panel (counter weight side).

OBG SEGMENT 7CW

This Quality Assurance (QA) Inspector observed ZPMC personnel performing thermal gas cutting with the help of guide tube at the side panel, bottom and deck panel edges.

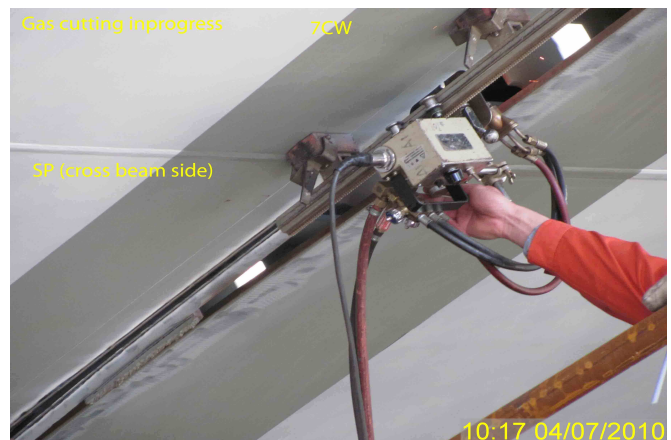
OBG SEGMENT 7AE

This Quality Assurance (QA) Inspector observed sand blasting in progress in OBG segment 7AE.

OBG SEGMENT 7CW

This Quality Assurance (QA) Inspector observed ZPMC personnel performing match drilling for bottom panel "T" rib stiffener near bottom panel splice weld between OBG segment 7BW and 7CW.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
